



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D4971-1
Job Sheet 186924



Part No: D4971-1

Job Qty: 4 ea

Part Name: T/R Bellcrank Cover



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 11/22/18

Job Tracking No:

Due Date: 12/7/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV A IPP REV:A 13.11.19 NEW ISSUE DD VERF:JLM IPP REV:B 14.04.01 PER DWG REV.A DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Waterjet - Flow - 1	4 pcs		12/7/18	0.00	0.43	Waterjet - Flow		SC 18/11/19
110	QC	4 pcs		12/7/18	0.00	0.00	QC2 Waterjet-1		SC 18/11/19
120	QC	4 pcs		12/7/18	0.00	0.00	QC8-5		38
130	Brake NC	4 pcs		12/7/18	0.04	0.40	Brake NC 1		9-88 DAS 30
140	QC	4 pcs		12/7/18	0.00	0.00	QC5		38 9-88
150	HandFinish	4 pcs		12/7/18	0.00	0.24	HandFinish1		DR 18/12/19
160	QC	4 pcs		12/7/18	0.00	0.00	QC7-4		BL 18-12-19
170	Powdercoat	4 pcs		12/7/18	0.00	0.16	Powdercoat4		BL 18-12-00
180	QC	4 pcs		12/7/18	0.00	0.00	QC3		DAS 38
190	Packaging	4 pcs		12/7/18	0.00	0.00	Packaging3-2	ST621	6 9-88
200	QC21-SA	4 Ea		12/7/18	0.00	0.00	QC21		9-88 21 DEC 2 2018

M 138834

START: 8:55

OV.T: 300° FINISH: 9:25

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6S.040	6061-T6 .040 Sheet	2.3600 sf (.59 ea)	100-Waterjet - Flow - 1	5180084

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Waterjet - Flow - 1	M6061T6S.040	2	220	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	T/R Bell Crank Cover	0.098Inches + 0.004 - 0.001	0.102 0.097	0,099	
2	T/R Bell Crank Cover	0.201Inches + 0.005 - 0.001	0.206 0.200	0,206	
3	T/R Bell Crank Cover	0.330Inches ± 0.030	0.360 0.300	0,333	
4	T/R Bell Crank Cover	2.500Inches ± 0.010	2.510 2.490	2,504	
5	T/R Bell Crank Cover	0.520Inches ± 0.030	0.550	0,524	

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Suspect ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Cross tube ☐ Small Fab ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Engineering ☐ Quality ☐ Other ☐					
Date : _____		Step #: _____		 Container No: S133250 Part: D4971-1 Job No: 186924 Serial No/Batch: S133250 Revision: _____ Inspector: _____ Exp Date: _____ Instructions: Various STC's Date: 11/29/18					
Description Work Order Deviation									
Root Cause <table style="width:100%; border-collapse: collapse;"> <tr> <td style="width:50%; vertical-align: top;"> Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ </td> <td style="width:50%; vertical-align: top;"> No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐ </td> </tr> </table>		Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	<table style="width:100%; border-collapse: collapse;"> <tr> <td style="width:50%; vertical-align: top;"> Pressure/Fo ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ </td> <td style="width:50%; vertical-align: top;"> BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ </td> </tr> </table>				Pressure/Fo ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐
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OTHER : _____									

			0.490	
6	T/R Bell Crank Cover	0.700Inches $\pm$ 0.030	0.730 0.670	0,707
7	T/R Bell Crank Cover	0.500Inches $\pm$ 0.030	0.530 0.470	0,508

Plex 11/22/18 2:01 PM Dart.lajeunesse.marie

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																	
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